

Date: Thursday, 03/07/2008 10:37:38 AM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HANDLE WELDMENT
Job Number :	40211		
Estimate Number :	10333		
P.O. Number :		Part Number :	D2530
This Issue :	03/07/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2530 REV B
First Issue :	11	Project Number :	N/A
Previous Run :	37853	Drawing Revision :	B
	Type : SMALL /MED FAB	Material :	
Written By :		Due Date :	10/07/2008
Checked & Approved By :	Qty: 19 Um: 20 Each		
Comment :	Est Rev:E Removed Purchasing 05-11-07 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 3.0602 f(s)/Unit Total: 61.2045 f(s)

Material: 304/316 SS Seamless Tubing 0.75" OD x 0.049" wall(M304TR0.750W.049)

Batch: M108498



2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2536

2-Deburr



3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP



4.0	D2534	Lock Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:

QTY	Part #	Description	Batch
2	D2534	Lock Plate	B32620-5



5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
8/7/14	# 5.0	only enough D2534 to make 19 D2530. Put one (1) D2536 in stock with B#40211		08/07/14	(1)		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 03/07/2008 10:37:38 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 40211

Part Number: D2530

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Deburr

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/07/14

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Soda/14 (19)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M102316

START TIME:

2:00pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

2:30pm

08-07-14

(19)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/07/14

(19)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 204

08/07/15 (19)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/16

Job Completion



MF 08-07-16

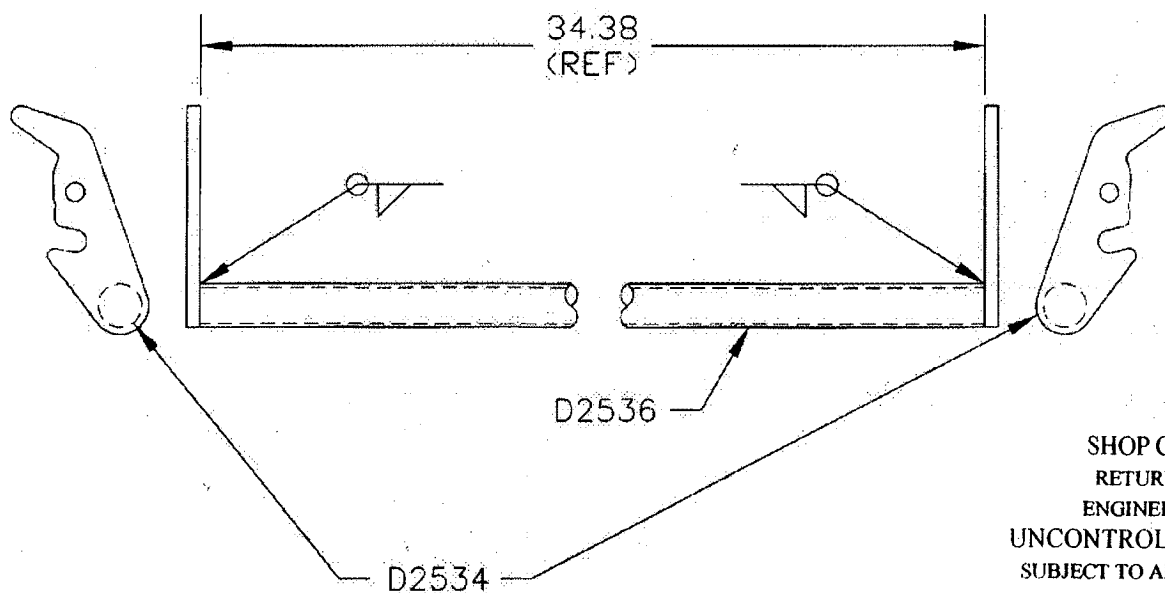


DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	PH	DRAWING NO.	REV. B
CHECKED <i>H</i>	APPROVED <i>H</i>	D2530	SHEET 1 OF 1
DATE	TITLE		SCALE
04.12.14	HANDLE WELDMENT		
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

RELEASED
04.12.16 *H*

PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40211

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED